

12

Date: Tuesday, 3/11/2008 1:17:33 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CABIN DOOR ROLLER KIT, RH
 Job Number : 37816
 Estimate Number : 10289
 P.O. Number :
 This Issue : 3/11/2008 S.O. No. :
 Prsht Rev. : NC Drawing Number : IIN D412-698 REVD
 First Issue : / / Project Number : N/A
 Previous Run : 36660 Type : MACHINED PARTS Drawing Revision : D
 Material :
 Due Date : 3/18/2008 Qty: 2 Um: Each
 Written By :
 Checked & Approved By : 08 03 11
 Comment : Est Rev:C 04.02.26 Change Qty of D3121-141 & remove
 D3121-145 from Step 1,3 KJ/DS
 Est Rev:D 08-01-28 change to rev D ECN 1104 DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-698-012 CHG003

08.03.14

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D3121141 Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Packing Kit

B37610 2X

Qty Part Number Description Batch

3 D3121-141 Bracket Assembly 36663 4X

4.0 D3121144 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3121-144 Bracket Assembly 34513

5.0 D3137043 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3137-043 Bracket Assembly 29725

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 1:17:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN DOOR ROLLER KIT, RH

Job Number: 37816

Part Number: D412698012

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D3183044

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3183-044

Bracket Assembly

36400

7.0

D31991

Bracket



Comment: Qty.: 9.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

9 D3199-1

Bracket

37435

8.0

D32021

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3202-1

Cover

35065

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/02 (x2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-012

Location:

Rev D

AS 08/04/01

(x2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W MF 08-04-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Part Number	Description
X							D412-698-011	CABIN DOOR ROLLER KIT, LH
	X						D412-698-012	CABIN DOOR ROLLER KIT, RH
		X					D412-698-013	DOOR HANDLE KIT
			X				D412-698-015	DOOR SUPPORT KIT
				X			D412-698-017	REPLACEMENT DOOR TRACK KIT
					X		D412-698-019	BEARING OVERHAUL KIT
						X	D412-698-021	REPLACEMENT SHIM KIT
					7		D3121-21	BOLT
					5		D3121-241	BEARING ASSEMBLY
3	3						D3121-141	BRACKET ASSEMBLY
1							D3121-143	BRACKET ASSEMBLY
	1						D3121-144	BRACKET ASSEMBLY
					1		D3137-3	GUIDE
					1		D3137-5	WASHER
1	1						D3137-043	BRACKET ASSEMBLY
					2		D3183-045	BEARING ASSEMBLY
1							D3183-043	BRACKET ASSEMBLY
	1						D3183-044	BRACKET ASSEMBLY
9	9			9			D3199-1	BRACKET
1	1			1			D3202-1	COVER
		4					D3203-1	HANDLE
		1					D3220-041	DOUBLER
		1					D3220-042	DOUBLER
		2					D3220-3	DOUBLER
			2				D3200-1	DOOR POST BLOCK
			2				D3200-3	DOOR WEDGE
			2				D3201-1	DOUBLER
			1				D3201-3	ANGLE
			1				D3201-4	ANGLE
						3	D3238-1	SHIM
						1	D3238-3	SHIM
						2	D3238-5	SHIM
						6	D3238-11	SHIM
						2	D3238-13	SHIM
						4	D3238-15	SHIM
			12				AN960JD10L	WASHER
		8					AN960JD416L	WASHER
			12				MS21042L3	NUT (OR MS21042-3)
		8					MS21042L4	NUT (OR MS21042-4)
		16					MS24694-S98	SCREW
					1		MS24694-S101	SCREW
			12				MS24693-S277	SCREW

(CONTINUED ON PAGE 15)

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Date: 07.07.03

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